

SHIP 10/10  
WED

Dart Aerospace Ltd.

Date: Wednesday, 10/3/2007 8:39:22 AM  
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT ARM
Job Number	: 34988		
Estimate Number	: 11488		
P.O. Number	: N/A	Part Number	: D31651
This Issue	: 10/3/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3165 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: A
		Material	: N/A
Written By	:	Due Date	: 10/20/2007
Checked & Approved By	: <u>JA 07.10.03</u>	Qty:	10
Comment	: Est. A 02.09.18 Newissue KJ	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"
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Comment: Qty.: 1.4963 f(s)/Unit Total: 8.9775 f(s)  
6061-T6 Bar .50" x 5.0"

Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) per (M6061T6B0.500x5000)

Batch M105646X7

M104598X3

mk 07/10/04

10

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut Blank: (17.00" x 5.00") +/- 0.030" x 0.500" thick

Grain along 17.000"

mk 07/10/04

10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA277 & Dwg D3165-1

Deburr & Tumble

mk 07/10/05

10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk 07/10/05

10

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

LS 07/10/06

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 2 Date: 01/18/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/3/2007 8:39:22 AM  
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ARM

Job Number: 34988

Part Number: D31651

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



x10

Comment: SMALL & MEDIUM FAB RESOURCE 1  
Engrave batch number as per Dwg D3165

*m-l 02/10/09*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



*(10x)*

Comment: HAND FINISHING RESOURCE #1  
Acid etch and Alodine as per QSI 005 4.1

*m-l*

*07/10/10*

8.0

POWDER COATING

POWDER COATING



*(10x)*

Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*m-l*

*07/10/10*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Pc 7/10/10*

*(10)*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

*Pc 7/10/10 - (20)*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*D 07/10/10*

Job Completion



*U 07-10-10*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

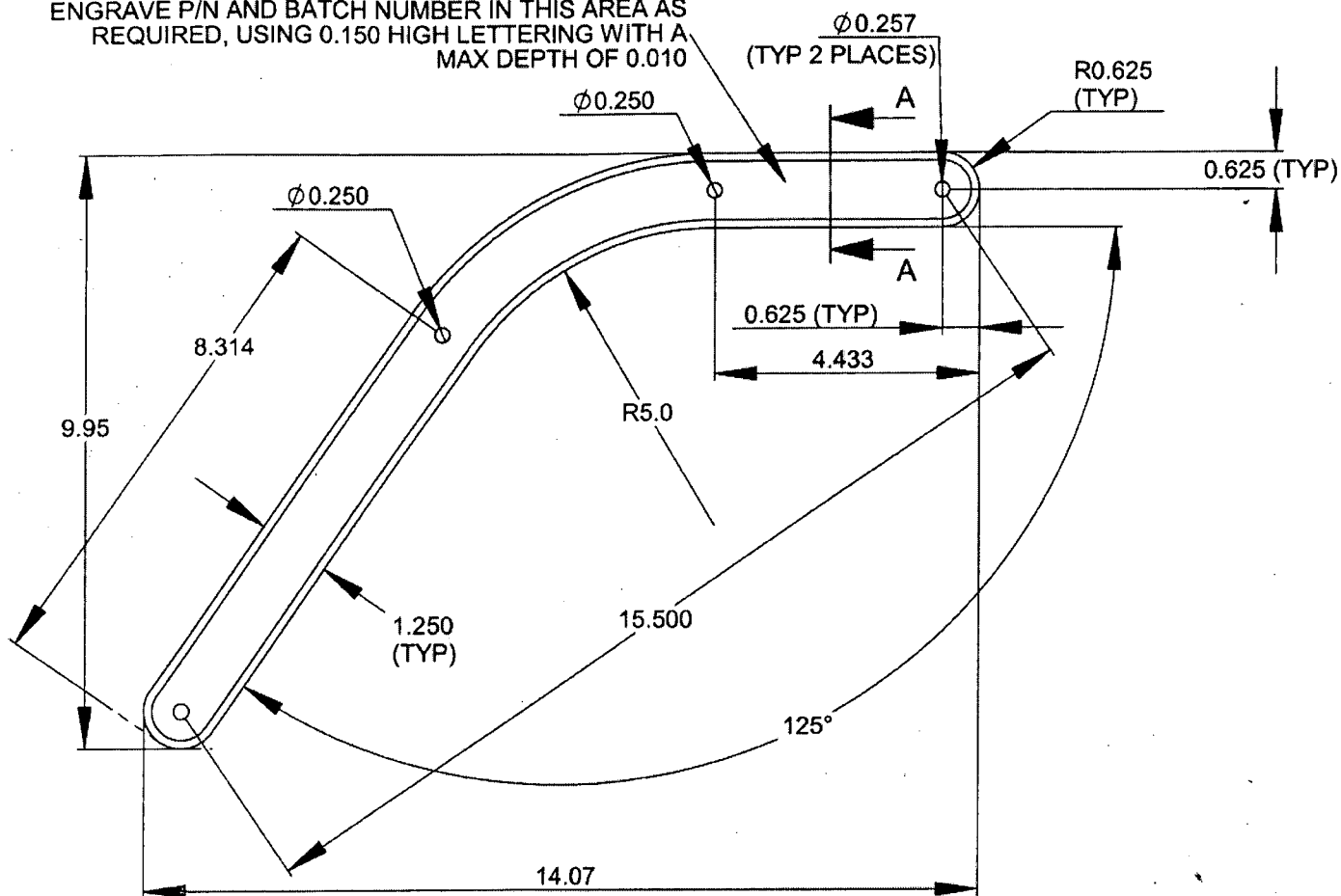
**NOTE:** Date & initial all entries





DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3165</b>	REV. A SHEET 1 OF 1
DATE <b>02.07.09</b>		TITLE <b>SUPPORT ARM</b>	SCALE 1:3
A	02.07.09	NEW ISSUE	

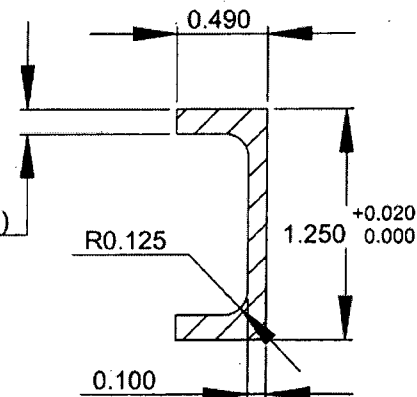
ENGRAVE P/N AND BATCH NUMBER IN THIS AREA AS REQUIRED, USING 0.150 HIGH LETTERING WITH A MAX DEPTH OF 0.010



**RELEASED**  
02.08.07

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **34988**

+0.020  
0.135 0.000 (TYP)



SECTION A-A  
SCALE (1 : 1)

**D3165-1 SUPPORT ARM**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) PER M6061T6B
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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